

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019035**Date Inspected:** 17-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

Notification no: 007396.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

Notification no: 007396.

- 1) SEG3014B-225
- 2) SEG3014F-075
- 3) SEG3015B-266
- 4) SEG3015D-324
- 5) SEG3015H-330
- 6) SEG3015C-138
- 7) SEG3015E-138

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- 8) SEG3015J-138
- 9) SEG3014C-138
- 10) SEG3014E-156
- 11) SEG3014J-156

This QA Inspector observed the following work in progress:

Corner Assembly for OBG Seg 13CW:

ABF NDE personnel performing UT of weld jt no: CA3016-100 [Edge Panel (EP) to Deck Panel (DP)]. 23 locations on this weld were marked for repair welding. Photo attached for further information.

OBG Seg 13AW:

This QA Inspector observed that the weld jt nos: SEG 3013Q-170 and SEG 3013P-258 [Rib Stiffener (RS) to Floor Beam (FB), at Panel Point (PP): 118] are required as complete joint penetration (CJP) welds. It was identified as; due to lack of sufficient access, these welds cannot be welded as CJP. This is discussed and informed to ZPMC QC and CT Engineer. ZPMC QC was identified as Li Ming Yang. Photos attached for further information.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3013E-161 [Bottom Panel (BP) to RS stiffener, partial joint penetration (PJP) weld]. The welder is identified as 070217 and was observed welding in the 2G position. ZPMC QC was identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with Welding Procedure Specification (WPS): B-T-2332-TC-P4-F.

OBG Seg 13BW:

The SMAW process on weld joint no: SEG301K-082 (FB to I-rib stiffener, fillet weld at PP121.5). The welder is identified as 037840 and was observed welding in the 4F position. ZPMC QC was identified as Sun Tian Ling. The welding variables recorded by QC appeared to comply with WPS: B-P-2114-FCM-1.

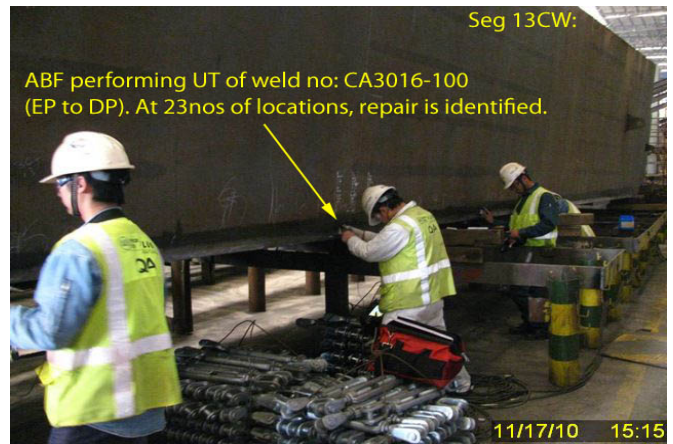
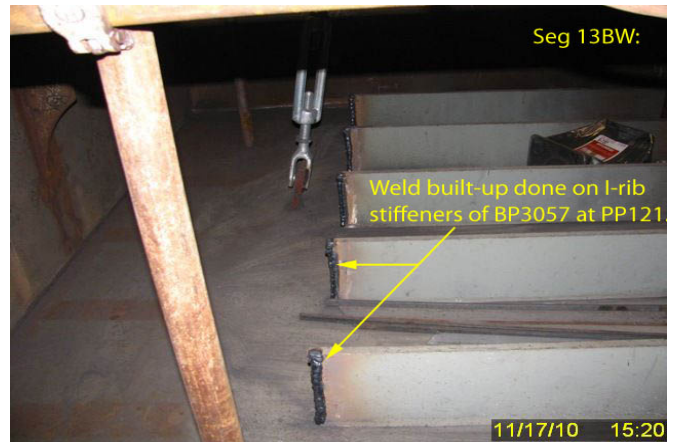
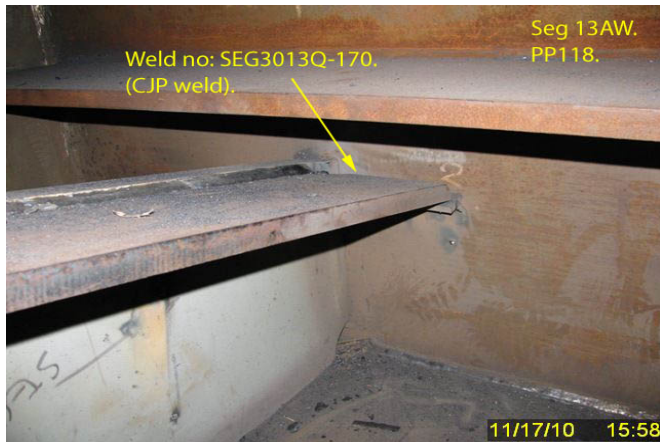
Repair welding of weld joint no: SEG3014N-003 [Side panel (SP) to SP; CJP weld at PP122]. The welder is identified as 045196 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 17170 Rev-0.

ZPMC performing weld built-up on I-ribs of Bottom Panel (BP) BP3057A at PP121. The welder is identified as 045143 and was observed welding in the 3G position. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC QC was identified as Sun Tian Ling. Repair welding was done as per WRR: B-WR 16207. Photo attached for further information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh
Reviewed By:	Patterson,Rodney

Quality Assurance Inspector
QA Reviewer
